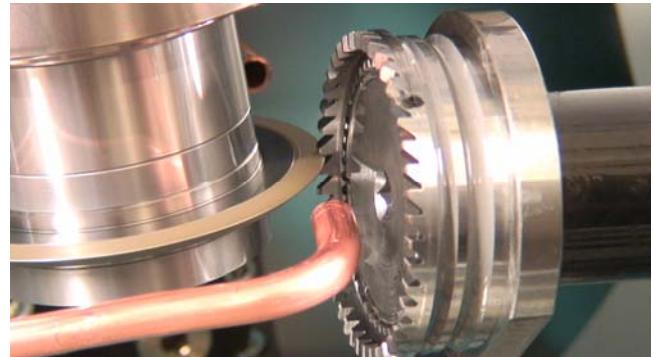


Denti di Lupo

A40-900

Il particolare lavorato è un ingranaggio del motore di un aereo. Vengono affilati i denti frontali chiamati denti di lupo. Per mezzo dell'abrichter CNC la mola è profilata con due angoli ben precisi secondo un profilo dxf.



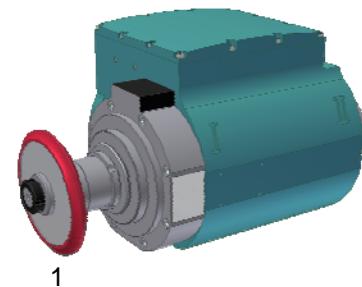
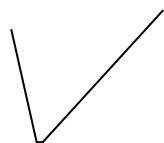
1. Cycletime for Production

Specifications			
Diameter 130 mm, Z5			
Operations	Probe	Dress	Cam
Feed [mm/Min]	2000	150	150
Power [kW]		1	1
Cutting feed [m/s]		32	24
Used wheels			1
Grinding time [s]	20	120	360
Total cycle time	8 Min 20		

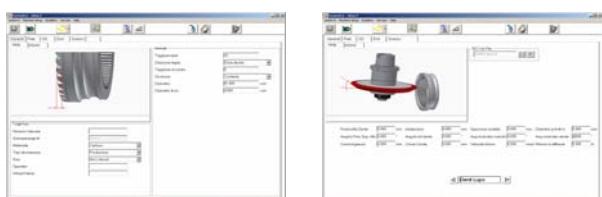
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 Ø36 DXF Conventional



3. Machine and Software Requirements



Machines: 5 axes CNC grinders : NORMA CFG
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 5, DXQ
 Engineer: Di, 01.04.2009